

What is claimed is:

1. A five layer shrink film comprising:
a first outer polyethylenic layer;
a second outer polyethylenic layer;
a core polystyrenic layer;
a first polystyrene compatibilizing layer between the core polystyrenic layer and the first outer polyethylenic layer; and
a second polystyrene compatibilizing layer between the core polystyrenic layer and the second outer polyethylenic layer;
wherein the polystyrene compatibilizing layers comprise less than 1% by weight substantially random interpolymer.
2. The film of claim 1 wherein the polyethylenic layers comprise at least 80% linear low density polyethylene copolymer.
3. The film of claim 2 wherein the linear low density polyethylene copolymer is a copolymer comprising from 1 to 10 weight percent 1-octene monomer.
4. The film of claim 1 wherein the polystyrenic layers comprise from 70% to 90% polystyrenic polymer and from 10% to 15% polystyrene toughener by weight of the layer.
5. The film of claim 4 wherein the polystyrene toughener is selected from the group of tougheners consisting of styrene-isoprene diblock copolymer, styrene-isoprene triblock copolymer, and blends of styrene-isoprene diblock copolymer and styrene-isoprene triblock copolymer.

6. The film of claim 4 wherein the polystyrenic layer further comprises 5 to 6% slip additives selected from the group of slip additives consisting of primary amides, secondary amides, ethylenebisamides and 13-docosenamide.
7. The film of claim 1 wherein the polystyrenic compatibilizing layers comprise from 70% to 90% linear low density polyethylene copolymer and from 5% to 20% of an adhesive resin used as a polystyrene compatibilizing agent, by weight of the layer.
8. The film of claim 7 wherein the adhesive resin is selected from the group of adhesive resins consisting of styrene-ethylene butylene-styrene block copolymer, anhydride-modified ethylene vinyl acetate, styrene-butadiene block copolymer, styrene-butadiene rubber, butadiene rubber, styrene-isoprene block copolymer, hydrogenated styrene-isoprene block copolymer, and styrene-butadiene-methyl methacrylate copolymer.
9. A method of forming a five layer shrink film comprising two outer most polyethylenic layers, an innermost polystyrenic layer and a polystyrene compatibilizing layer situate between each outermost polyethylenic layer and the core polystyrenic layer comprising less than 1% by weight substantially random interpolymer, the method comprising of:
feeding individual layer compositions into 3 or more separate extruders;
extruding the compositions simultaneously into a biaxial film orienting means; and
biaxially orienting the film to a thickness of 40 to 100 gauge;

wherein a separate extruder extrudes a single homogenous composition.

10. The method of claim 9 wherein the biaxial film orienting means consists of a double-bubble film orienting process.
11. The method of claim 9 wherein the polyethylenic layers comprise at least 80% linear low density polyethylene copolymer.
12. The method of claim 11 wherein the linear low density polyethylene copolymer is a copolymer comprising from 1 to 10 weight percent 1-octene monomer.
13. The method of claim 9 wherein the polystyrenic layers comprise from 70% to 90% polystyrenic polymer and from 10% to 15% polystyrene toughener by weight of the layer.
14. The method of claim 13 wherein the polystyrene toughener is selected from the group of tougheners consisting of styrene-isoprene diblock copolymer, styrene-isoprene triblock copolymer, and blends of styrene-isoprene diblock copolymer and styrene-isoprene triblock copolymer.
15. The method of claim 13 wherein the polystyrenic layer further comprises 5 to 6% slip additives selected from the group of slip additives consisting of primary amides, secondary amides, ethylenebisamides and 13-docosenamide.
16. The method of claim 9 wherein the polystyrenic compatibilizing layers comprise from 70% to 90% linear low density polyethylene copolymer and from 5% to 20% of an adhesive resin used as a polystyrene compatibilizing agent, by weight of the layer.

17. The method of claim 16 wherein the adhesive resin is selected from the group of adhesive resins consisting of styrene-ethylene butylene-styrene block copolymer, anhydride-modified ethylene vinyl acetate, styrene-butadiene block copolymer, styrene-butadiene rubber, butadiene rubber, styrene-isoprene block copolymer, hydrogenated styrene-isoprene block copolymer, and styrene-butadiene-methyl methacrylate copolymer.
18. A five layer shrink film comprising:
 - a first outer polystyrenic layer;
 - a second outer polystyrenic layer;
 - a core polyethylenic layer;
 - a first polystyrene compatibilizing layer between the core polyethylenic layer and the first outer polystyrenic layer; and
 - a second polystyrene compatibilizing layer between the core polyethylenic layer and the second outer polystyrenic layer;wherein the polystyrene compatibilizing layers comprise less than 1% by weight substantially random interpolymer.
19. The film of claim 18 wherein the polyethylenic layers comprise at least 80% linear low density polyethylene copolymer.
20. The film of claim 19 wherein the linear low density polyethylene copolymer is a copolymer comprising from 1 to 10 weight percent 1-octene monomer.
21. The film of claim 18 wherein the polystyrenic layers comprise from 70% to 90% polystyrenic polymer and from 10% to 15% polystyrene toughener by weight of the layer.

22. The film of claim 21 wherein the polystyrene toughener is selected from the group of tougheners consisting of styrene-isoprene diblock copolymer, styrene-isoprene triblock copolymer, and blends of styrene-isoprene diblock copolymer and styrene-isoprene triblock copolymer.
23. The film of claim 21 wherein the polystyrenic layer further comprises 5 to 6% slip additives selected from the group of slip additives consisting of primary amides, secondary amides, ethylenebisamides and 13-docosenamide.
24. The film of claim 18 wherein the polystyrenic compatibilizing layers comprise from 70% to 90% linear low density polyethylene copolymer and from 5% to 20% of an adhesive resin used as a polystyrene compatibilizing agent, by weight of the layer; and wherein the adhesive resin is selected from the group of adhesive resins consisting of styrene-ethylene butylene-styrene block copolymer, anhydride-modified ethylene vinyl acetate, styrene-butadiene block copolymer, styrene-butadiene rubber, butadiene rubber, styrene-isoprene block copolymer, hydrogenated styrene-isoprene block copolymer, and styrene-butadiene-methyl methacrylate copolymer.
25. A five layer shrink film comprising:
a first outer polyethylenic layer comprising 15 to 25% by weight of the film;
a second outer polyethylenic layer comprising 15 to 25% by weight of the film;
a core polystyrenic layer comprising 30 to 50% by weight of the film;

a first polystyrene compatibilizing layer between the core polystyrenic layer and the first outer polyethylenic layer comprising 10 to 25% by weight of the film;

a second polystyrene compatibilizing layer between the core polystyrenic layer and the second outer polyethylenic layer comprising 10 to 25% by weight of the film;

wherein the polystyrene layer comprise 70% to 90% polystyrenic polymer; from 10% to 15% polystyrene toughener and from 5% to 6% slip additive, by weight of the layer;

wherein the polystyrene compatabilizing layers comprise less than 1% by weight substantially random interpolymers; and

wherein the polystyrene compatabilizing layers comprise 5% to 20% anhydride-modified ethylene vinyl acetate, by weight of the layer.

26. A five layer shrink film comprising:
- a first outer polyethylenic layer comprising 15 to 25% by weight of the film;
- a second outer polyethylenic layer comprising 15 to 25% by weight of the film;
- a core polystyrenic layer comprising 30 to 50% by weight of the film;
- a first polystyrene compatibilizing layer between the core polystyrenic layer and the first outer polyethylenic layer comprising 10 to 25% by weight of the film;

a second polystyrene compatibilizing layer between the core polystyrenic layer and the second outer polyethylenic layer comprising 10 to 25% by weight of the film;

wherein the polystyrene layer comprise 70% to 90% polystyrenic polymer; from 10% to 15% polystyrene toughener and from 5% to 6% slip additive, by weight of the layer;

wherein the polystyrene compatabilizing layers comprise less than 1% by weight interpolymer; and

wherein the polystyrene compatabilizing layers comprise 5% to 20% styrene-ethylene butylene-styrene block copolymer.